

Work Order ID 61327

Wednesday, August 18, 2010 11:06:39 AM



Page 1

Item ID: D3574-5

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 8/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: unf Date: 10-8-18

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 10-8-18

(2)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-8-18

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/18/2010

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

8/20/08/19 (2)

8/10/08/19

(42)

10/8/19 SL (20)

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Required Date: 8/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19 MF
10-8-19

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Picklist Print

Wednesday, August 18, 2010 11:06:39 AM

Page 1

Work Order ID: 61327



Parent Item: D3574-5



Parent Item Name: Cabin Floor Protector

Start Date: 8/18/2010

Required Date: 8/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,885.923	33.6	67.23362			
												1810-8-18	
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

MAT

2885.9238

114032

467.9238

115261

2418

115261

2

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	61327
Description: Cabin Floor Protector		Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.004	X		U HB02	
7.37	+/-0.030	7.37	X		T HB01	
11.00	+/-0.030	11.00	X		T	
15.25	+/-0.030	15.25	X		T	
25.87	+/-0.030	25.87	X		T	
39.75	+/-0.030	39.75	X		T	
44.75	+/-0.030	44.75	X		T	
49.11	+/-0.030	49.11	X		T	
51.11	+/-0.030	51.11	X		T	
1.75	+/-0.030	1.75	X		T	
58.38	+/-0.030	58.38	X		T	
63.50	+/-0.030	63.50	X		T	
65.25	+/-0.030	65.25	X		T	
11.87	+/-0.030	11.87	X		T	
14.75	+/-0.030	14.75	X		T	
26.00	+/-0.030	26.00	X		T	
40.87	+/-0.030	40.87	X		T	
45.00	+/-0.030	45.00	X		T	
48.00	+/-0.030	48.00	X		T	
55.13	+/-0.030	55.13	X		T	
58.38	+/-0.030	58.38	X		T	
61.25	+/-0.030	61.25	X		T	
61.88	+/-0.030	61.88	X		T	
64.63	+/-0.030	64.63	X		T	
7.63	+/-0.030	7.63	X		T	
11.00	+/-0.030	11.00	X		T	
22.50	+/-0.030	22.50	X		T	
35.13	+/-0.030	35.13	X		T	
36.50	+/-0.030	36.50	X		T	
40.00	+/-0.030	40.00	X		T	
41.88	+/-0.030	41.88	X		T	
43.63	+/-0.030	43.63	X		T	
6.75	+/-0.030	6.75	X		T	

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Description: Cabin Floor Protector		Part Number:	D3574-5
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.56	x		T AB01	
10.38	+/-0.030	10.38	2		T	
14.50	+/-0.030	14.50	8		T	
16.75	+/-0.030	16.75	2		T	
19.00	+/-0.030	19.00	8		T	
24.13	+/-0.030	24.13	2		T	
33.88	+/-0.030	33.88	2		T	
39.50	+/-0.030	39.56	8		T	
40.25	+/-0.030	40.28	1		T	
43.50	+/-0.030	43.56	7		T	
43.83	+/-0.030	43.83	8		T	
46.60	+/-0.030	46.60	2		T	
0.125	+/-0.010	.130	x		V AB02	

Measured by: AB	Audited by: S	Prototype Approval:	N/A
Date: 10-8-18	Date: 10/08/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	HA

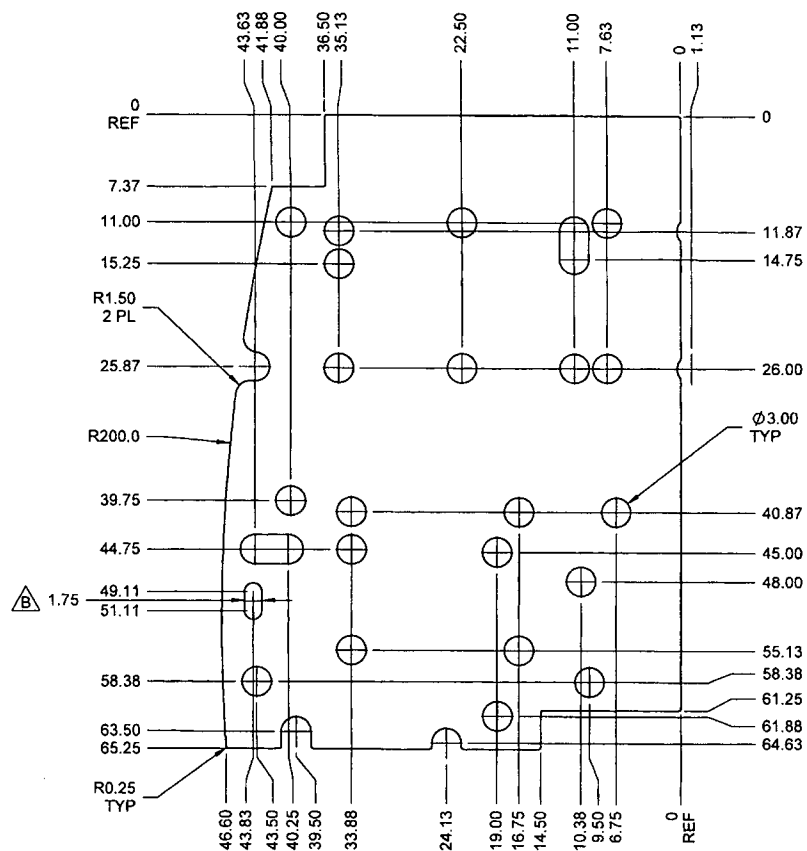
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D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3574	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
01/04/07

W/O:		WORK ORDER CHANGES					
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